

**WHAT IS CLAIMED IS:**

1. A light emitting device comprising a pixel portion comprising:  
a light emitting element comprising:
  - 5 a first transparent electrode;
  - a second transparent electrode; and
  - a layer between the first and second transparent electrodes, the layer comprising a first light emitting layer comprising an organic metal complex; and
  - 10 a color filter,wherein the light emitting element simultaneously generate blue color light, phosphorescence from the organic metal complex, and excimer light emission from the organic metal complex so as to generate white color light emission,
  - 15 wherein white color light emission passing through the first transparent electrode generates full color display by the color filter, and
  - wherein white color light emission passing through the second transparent electrode generates monochrome display.
- 20 2. A light emitting device comprising a pixel portion comprising:  
a light emitting element comprising:
  - a first transparent electrode;
  - a second transparent electrode; and
  - a layer between the first and second transparent electrodes, the
  - 25 layer comprising a first light emitting layer comprising an organic metal complex;

a color filter;

a first polarizing plate; and

a second polarizing plate,

wherein the light emitting element simultaneously generate blue color

5 light, phosphorescence from the organic metal complex, and excimer light  
emission from the organic metal complex so as to generate white color light  
emission,

wherein white color light emission passing through the first transparent  
electrode generates a full color display by the color filter and the first polarizing  
10 plate, and

wherein white color light emission passing through the second  
transparent electrode generates monochrome display by the second polarizing  
plate.

15 3. A light emitting device according to claim 1,

wherein the layer between the first and second transparent electrodes  
further comprises a second light emitting layer that emits the blue color light;

wherein the first light emitting layer simultaneously generates a  
phosphorescence emission and an excimer light emission from the organic metal  
20 complex.

4. A light emitting device according to claim 2,

wherein the layer between the first and second transparent electrodes  
further comprises a second light emitting layer that emits the blue color light;

25 wherein the first light emitting layer simultaneously generates a  
phosphorescence emission and an excimer light emission from the organic metal

complex.

5           5. A light emitting device according to claim 1,  
              wherein the first light emitting layer further comprises a host material,  
              and  
              wherein the organic metal complex is mixed with the host material at a  
concentration of between 10 wt% and 40 wt%.

10           6. A light emitting device according to claim 2,  
              wherein the first light emitting layer further comprises a host material,  
              and  
              wherein the organic metal complex is mixed with the host material at a  
concentration of between 10 wt% and 40 wt%.

15           7. A light emitting device according to claim 5, wherein the  
concentration of the organic metal complex is between 12.5 wt% and 20 wt%.

              8. A light emitting device according to claim 6, wherein the  
concentration of the organic metal complex is between 12.5 wt% and 20 wt%.

20           9. A light emitting device according to claim 3, wherein the layer  
between the first and second transparent electrodes further comprises an electron  
transporting layer.

25           10. A light emitting device according to claim 4, wherein the layer  
between the first and second transparent electrodes further comprises an electron

transporting layer.

11. A light emitting device according to claim 2, wherein a first direction of a first polarizing axis of the first polarizing plate is perpendicular to  
5 the second polarizing axis of the second polarizing plate.

12. A light emitting device comprising a pixel portion comprising:  
a light emitting element comprising:  
a first transparent electrode;  
10 a second transparent electrode; and  
a layer between the first and second transparent electrodes, the layer comprising a first light emitting layer comprising an organic metal complex;  
a first color filter comprising:  
15 a red color layer;  
a green color layer; and  
a blue color layer;  
a second color filter comprising one of colored layers of red, blue and green,  
20 wherein the light emitting element simultaneously generate blue color light, phosphorescence from the organic metal complex, and excimer light emission from the organic metal complex so as to generate white color light emission,  
wherein white color light emission passing through the first transparent  
25 electrode generates full color display by the first color filter, and  
wherein white color light emission passing through the second

transparent electrode generates monochrome display by the second color filter.

13. A semiconductor device comprising the light emitting device according to claim 1, wherein the semiconductor device is selected from the group consisting of a video camera, a digital camera, a personal computer, and a portable information terminal.

14. A semiconductor device comprising the light emitting device according to claim 2, wherein the semiconductor device is selected from the group consisting of a video camera, a digital camera, a personal computer, and a portable information terminal.

15. A semiconductor device comprising the light emitting device according to claim 12, wherein the semiconductor device is selected from the group consisting of a video camera, a digital camera, a personal computer, and a portable information terminal.

16. A manufacturing apparatus comprising:  
a loading chamber;  
a transporting chamber connected to the loading chamber;  
a plurality of film formation chambers connected to the transporting chamber; and  
an installation chamber connected to the plurality of film formation chambers,  
wherein the plurality of film formation chambers is connected to a vacuum exhaust processing chamber for evacuating inside of each of the film

formation chambers, and

each of the film formation chambers comprising:

means for fixing a substrate;

means for aligning masks and the substrate;

5 one evaporation source or two evaporation sources;

means for transporting the evaporation source in the film formation chambers and the installation chamber; and

means for heating the substrate,

wherein the manufacturing device further comprising:

10 a first film formation chamber for forming a first light emitting layer which emits blue color light by vapor deposition on the surface formed over the substrate;

a second film formation chamber for forming a second light emitting layer which contains a phosphorescent material and simultaneously emits  
15 phosphorescence from the phosphorescent material and light from the phosphorescent material in an excimer state over the first light emitting layer by coevaporation; and

a third film formation chamber for forming an electron transporting layer over the second light emitting layer by vapor deposition.

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